

Work Order ID 71662 -1

October-14-11 11:46:30 AM

71662

Page 1

Item ID: D3255-041
 Revision ID:
 Item Name: Access Panel Assembly
 Start Date: 7/07/11 Start Qty: 4.00
 Required Date: 7/21/11 Req'd Qty: 4.00
 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan:
 QC:

Date:
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/
 Work Center ID Operation
 Description

Set Up/
 Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
 Code Qty Qty Number Stamp

Draw Nbr Revision Nbr

D3255 Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD
 Batch: 1110798 2-Grind Welds Flush

11/10/18

110

QC10- Inspect visual per QSI004- ground welds

0.00

110

QC

Memo

0.00

Quality Control

11/10/18

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

11/10/18

+2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 71662

October-14-11 11:46:30 AM

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Page 2

Item ID: D3255-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Access Panel Assembly

Start Date: 7/07/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/11 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200

4:20

2x Ø m-f 11/10/18

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

2
couv

11/10/18

150

Small Fab

0.00

150

Small Fab

Small Fab

Memo

0.00

1-Bond D3255-5 gasaket to d3255-041 using Dow coming adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: 1116664

SA 11/10/20

Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 71662

71662

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October-14-11 11:46:30 AM

Item ID: D3255-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Access Panel Assembly

Start Date: 7/07/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/11 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 170

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

11/10/20 8/21

11/10/20 JF
UMF
11-10-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

October-14-11 11:46:30 AM

Page 1

Work Order ID: 71662
Parent Item: D3255-041

Start Date: 7/07/11

Required Date: 7/21/11

Parent Item Name: Access Panel Assembly

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3255-1 Panel | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 4 | | | |
|------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

Location

Loc Qty

Loc Code

WA
71636
72191

6
2
4

(2x)

11/10/18

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D3255-3 Cap | | Manufactured | No | | | 150 | Each | 14.0000 | 1 | 4 | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|

Location

Loc Qty

Loc Code

WA
72152

14
14

(2x)

11/10/18

| | | | | | | | | | | | | | |
|-------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| D3255-5 Gasket | | Manufactured | No | | | 100 | Each | 9.0000 | 1 | 4 | | | |
|-------------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

Location

Loc Qty

Loc Code

GA
72118

9
9

SB 11/10/18

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

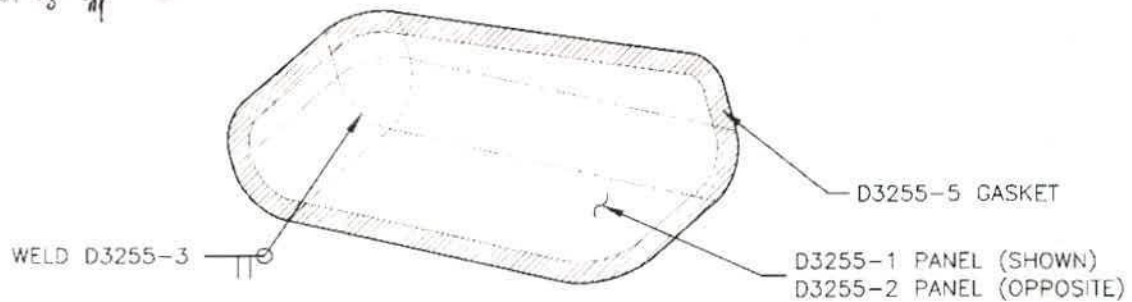
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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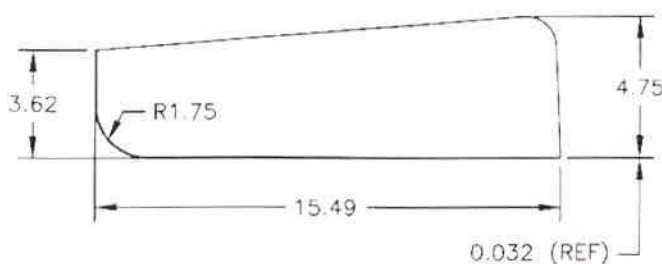
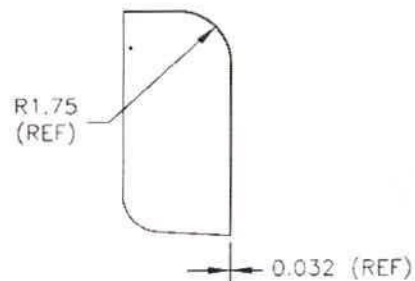
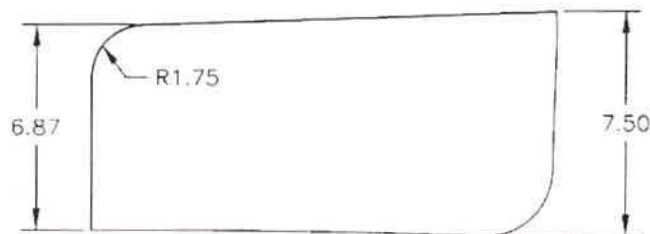
NOTE: Date & initial all entries

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN 27 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED if | APPROVED H | DRAWING NO. D3255 | REV. B SHEET 1 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:6 |
| A | 04.01.27 | NEW ISSUE | |
| B | 04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098 | |

RELEASED
05.01.08 H

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



w/ 071662

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

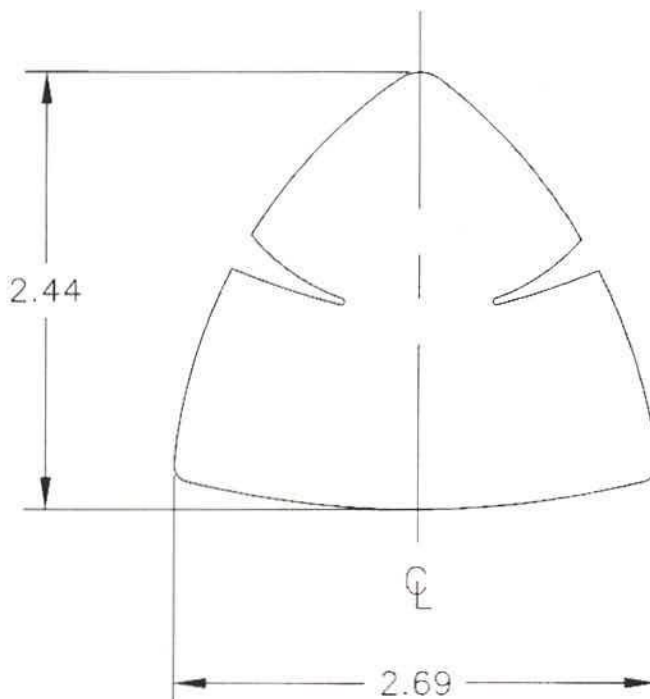
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|------------------|----------------|---|------------------------|
| DESIGN 11 | DRAWN BY 11 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED P | APPROVED H | DRAWING NO. D3255 | REV. B SHEET 2 OF 4 |
| DATE 04.12.06 | | TITLE TITLE | SCALE 1:1 |

OS 01 18 H



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

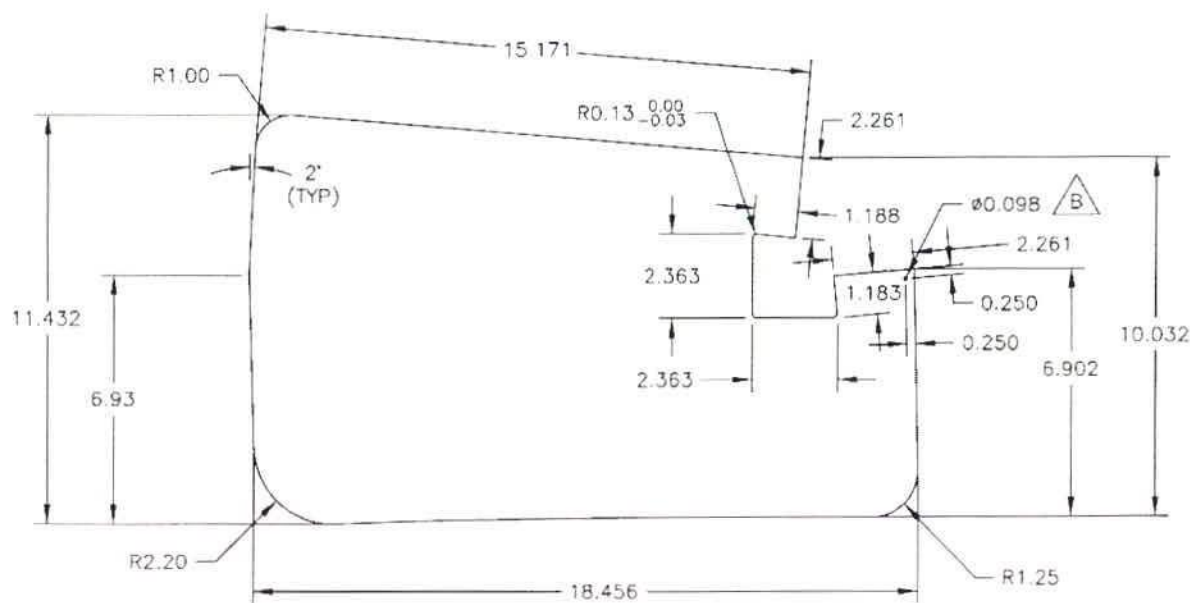
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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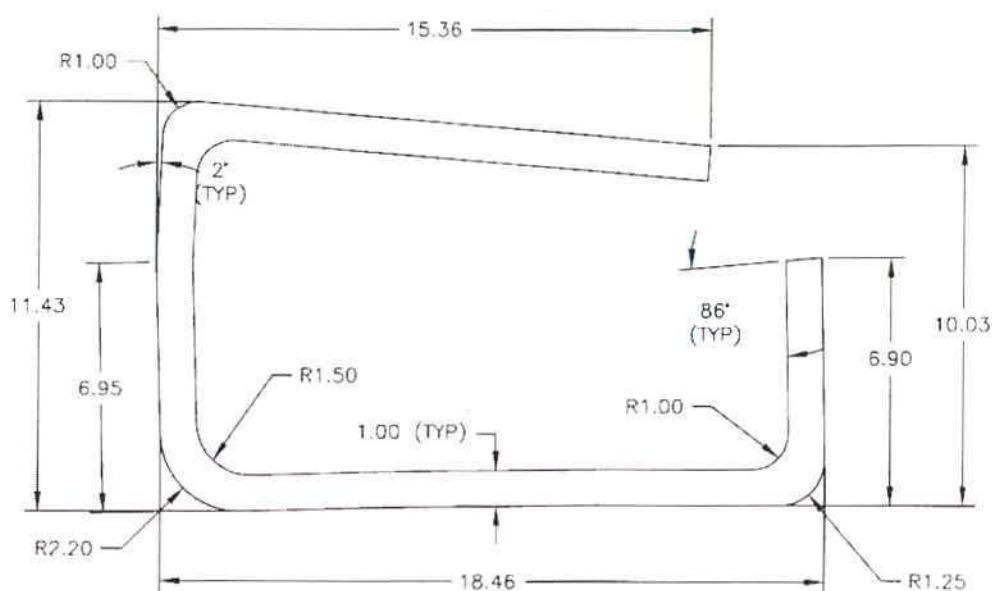
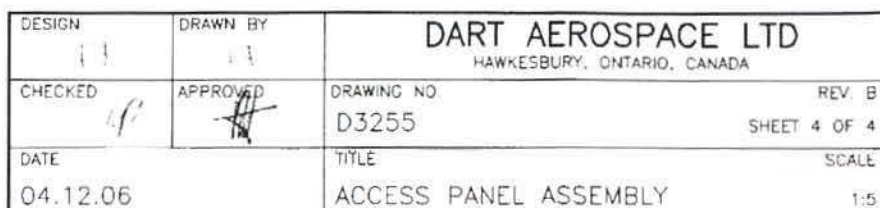
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| DESIGN 13 | DRAWN BY 17 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED P | APPROVED H | DRAWING NO. D3255 | REV. B SHEET 3 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

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